

Work Order ID 48590D

Friday, June 26, 2009 11:51:31 AM

Page 1

Item ID: D3822-5KIV

Accept

Setup Start

Revision ID: B C BL

Stop

Item Name: Vertical Tunnel, Top-Ivory

Start Date: 7/15/2009 Start Qty: 3.00

Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

100

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Machine Set-Up

BB 09/07/07

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Cut Sheet to required Blank size

M109703

BB 09/07/07

120

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg and Folio #FTA028 using tool DT9078

Dwg Rev: _____

Folio Rev: _____

BB 09/07/07 (X6)

Work Order ID 48590D

Page 2

Friday, June 26, 2009 11:51:31 AM

Item ID: D3822-5KIV
Revision ID: *BC*
Item Name: Vertical Tunnel, Top-Ivory

Accept



Setup Start



Stop



Start Date: 7/15/2009 Start Qty: 3.00
Required Date: 8/3/2009 Req'd Qty: 3.00



Cust Item ID:
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	<i>BB 09/07/07 X6</i>				_____	_____	_____
140 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>BB 09/07/08 X6</i>				_____	_____	_____
150 Thermoform Thermoforming Machine	Memo 1-Trim to finished dimensions as per Dwg	0.00 0.00	<i>BB 09/07/09 X6</i>				_____	_____	_____

Work Order ID 48590D

Friday, June 26, 2009 11:51:31 AM



Page 3

Item ID: D3822-5KIV

Accept



Setup Start



Revision ID: BC A6

Stop



Item Name: Vertical Tunnel, Top-Ivory

Start Date: 7/15/2009 Start Qty: 3.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev. Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC2- Inspect parts off machine FAI/FAIB



QC

Memo

Quality Control

0.00

0.00

BB 09/07/09 X6

170

QC5- Inspect part completeness to step on W/O



QC

Memo

Quality Control

0.00

0.00

⇒ 09/07/09 X6

180

Identify as per dwg & Stock Location: _____



Packaging

Memo

Packaging

0.00

0.00

9/7/09 X6 SP

Work Order ID 48590D

Friday, June 26, 2009 11:51:31 AM



Page 4

Item ID: D3822-5KIV

Accept



Setup Start

Revision ID: *B H.*

Stop



Item Name: Vertical Tunnel, Top-Ivory

Start Date: 7/15/2009 Start Qty: 3.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/10 *[Signature]*
MF 09-07-10

Date: Monday, 15/06/2009 4:19:53 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : VERTICAL TUNNEL TOP, IVORY
Job Number : 48590D	
Estimate Number : 13588	
P.O. Number :	Part Number : D38225KIV
This Issue : 15/06/2009 S.O. No. :	Drawing Number : D3822-5
Prsht Rev. : NC	Project Number :
First Issue : / / Type : THERMOFORMING	Drawing Revision : BB
Previous Run : 47672D	Material : MKYD6185S080P362015
Written By :	Due Date : 22/06/2009 Qty : 3 mf
Checked & Approved By : JUD 09.06.15	Um : 5 Each
Comment : Est. A New Issue 08/09/17 DL Rev B Dwg. Update 09/02/09 DL verified by:DD Est Rev. C Add Colour Code 09/06/02 DL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MKYD6185S080P362015	6185 KYDEX .080"
-----	---------------------	------------------



Comment: Qty.: 0.7120 sf(s)/Unit Total : 3.5600 sf(s)
 6185 Kydex .080" Ivory

M109703

BB

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------

**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/07/07

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------

**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/07/07 X1

4.0	THERMOFORMING	THERMOFORMING MACHINE
-----	---------------	-----------------------

**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3822-5 and folio FTA 028 using tool DT 9078

Dwg. Rev. S

Folio Rev. B

BB 09/07/07 X6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 15/06/2009 4:19:53 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUNNEL TOP, IVORY

Job Number: 48590D

Part Number: D38225KIV

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/07/07 (x6)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

DL 09/07/08 (x6)

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 09/07/09 (x6)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 09/07/09 x6

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/07/09 (x6)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 485900
Description: vertical Tunnel Top Wing	Part Number: D3822-5412
Inspection Dwg: D3822-5 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: RB

Date: 09/07/09

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.3	Min	.389	✓			
.040	.040	.066	✓			
.060		.070	✓			

Measured by: RB

Date: 09/07/09

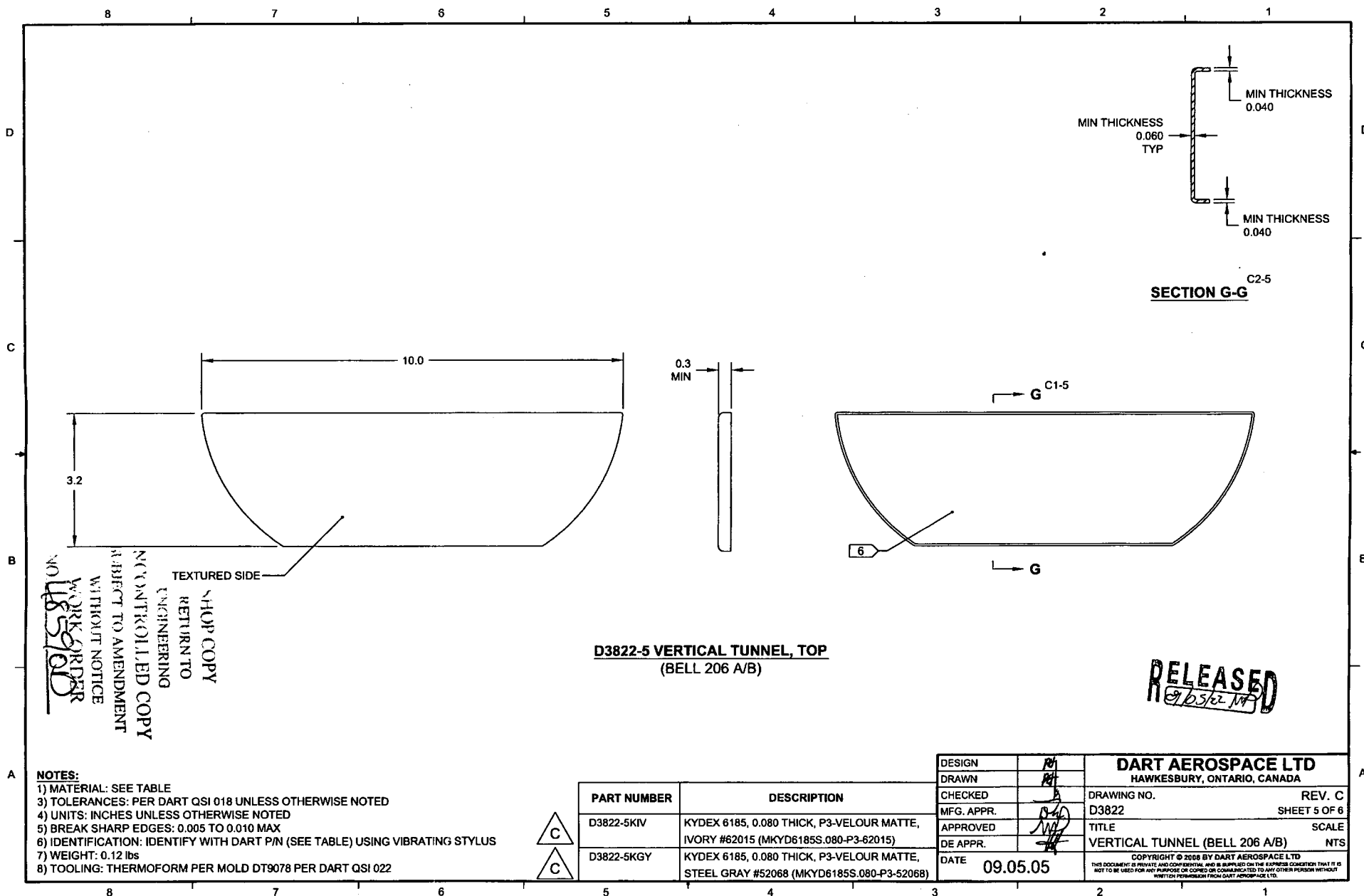
Audited by: S

Date: 09/07/09

Prototype Approval: n/a

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

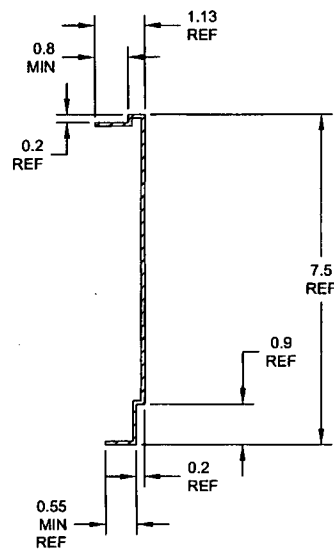
8 7 6 5 4 3 2 1

D

C

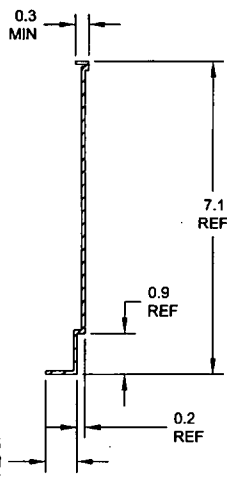
B

A



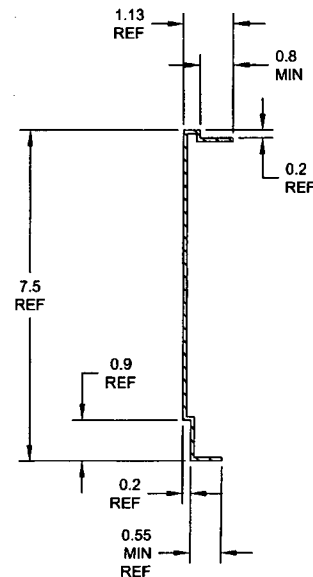
SECTION A-A

C6-1



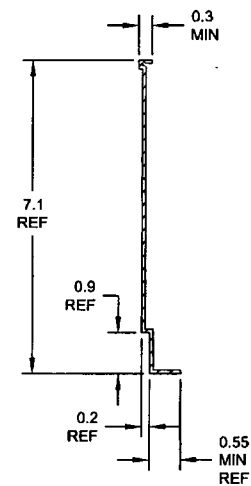
SECTION B-B

C6-1



SECTION C-C

C4-2



SECTION D-D

C4-2

D

C

B

A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 285100

RELEASED
09/05/05

DESIGN	RA	DART AEROSPACE LTD	
DRAWN	RA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RA	DRAWING NO.	REV. C
MFG. APPR.	RA	D3822	SHEET 3 OF 6
APPROVED	RA	TITLE	SCALE
DE APPR.	RA	VERTICAL TUNNEL (BELL 206 A/B)	NTS
DATE	09.05.05	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries